

Friday, 09/05/2008 1:45:31 PM  
Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206/OH-58 SADDLE, INBOARD, RIGHT SIDE
<b>Job Number</b> :	39157	<b>Part Number</b> :	D29332
<b>Estimate Number</b> :	10834	<b>Drawing Number</b> :	D2933 REV C
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	09/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	C
<b>First Issue</b> :	///	<b>Material</b> :	
<b>Previous Run</b> :	37423	<b>Due Date</b> :	30/05/2008
<b>Written By</b> :		<b>Qty:</b>	6
<b>Checked &amp; Approved By</b> :	JUL 08.5.09	<b>Um:</b>	Each
<b>Comment</b> :	Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101001	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: B 34872

DIP 08/07/02

(6)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

DIP 08/07/02

(70)

(6)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

DIP 08/07/02

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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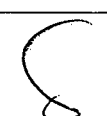
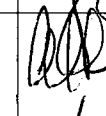
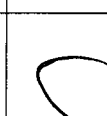
**Comment:** INSPECT ALL DIM TO DIM SHEET

DIP 08/07/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2933-2 PAR #: N/A Fault Category: Prod / Machine NCR: Yes No DQA: D Date: 08/07/08  
D 226-642 QA: N/C Closed: D Date: 08/07/08

NCR: 39157		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/02	2.0	Forgot to tight bolts on 4axe. ø.257 hole → intersection tool #4 →  operator fault	 02/07/03	SCRAP/DESTROY 4ø.257.03  Replace: <u>B#34872</u>	08/07/01 DTP	 08/07/03	 08/07/03	 08/07/03

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:45:31 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 39157

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 08/07/03 (6)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/07/04 (6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

7:25

OVEN TEMPERATURE:

320

FINISH TIME:

7:55

FL 08/07/07 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BL 08-07-07 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 422A

8/7/2

(6)

SLP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08

Job Completion



2 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 39157
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.115	0.115	0.114	0.114		
B	0.100	0.140		0.112	0.112	0.113	0.114		
C	0.100	0.140		0.118	0.119	0.121	0.121		
D	0.210	0.230		0.221	0.221	0.2185	0.219		
E	1.245	1.255		1.248	1.248	1.250	1.249		
F	1.245	1.255		1.249	1.250	1.249	1.249		
G	2.495	2.505		2.500	2.500	2.501	2.501		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.576	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.316	0.3155	0.3155	0.3155		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.121	0.121	0.119	0.1195		
O	0.540	0.560		0.552	0.552	0.552	0.552		
P	0.490	0.510		0.499	0.501	0.500	0.499		
Q	3.715	3.725		3.720	3.720	3.719	3.719		
R	2.470	2.510		2.497	2.497	2.497	2.497		
S	0.240	0.270		0.250	0.249	0.249	0.250		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.630	1.629	1.629		
V	1.362	1.372		1.367	1.366	1.367	1.367		
W	0.316	0.321		0.321	0.321	0.321	0.321		
X	1.125	1.145		1.1345	1.1345	1.1335	1.1335		
Y	1.565	1.585	DT8695 A/B	1.5725	1.572	1.572	1.572		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: 
Date: 08/07/02

Audited by: 
Date: 08/07/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim: X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 39157
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2933-2
<b>Inspection Dwg:</b> D2933 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		0.115	0.115	0.120			
B	0.100	0.140		0.112	0.113	0.120			
C	0.100	0.140			0.128	0.130			
D	0.210	0.230		0.2185	0.219	0.218			
E	1.245	1.255			1.249	1.250			
F	1.245	1.255			1.250	1.250			
G	2.495	2.505			2.500	2.500			
H	0.510	0.515			0.511	0.510			
I	1.572	1.582		1.576	1.577	1.577			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		0.259	0.259	0.259			
L	0.312	0.317			0.316	0.316			
M	0.235	0.240			0.238	0.238			
N	0.100	0.140		0.119	0.119	0.118			
O	0.540	0.560		0.5515	0.552	0.553			
P	0.490	0.510			0.4985	0.498			
Q	3.715	3.725		3.720	3.721	3.720			
R	2.470	2.510		2.497	2.497	2.497			
S	0.240	0.270		0.260	0.248	0.2525			
T	0.100	0.180		0.141	0.140	0.140			
U	1.625	1.635		1.629	1.630	1.630			
V	1.362	1.372		1.366	1.366	1.367			
W	0.316	0.321		0.321	0.321	0.321			
X	1.125	1.145		1.1335	1.1335	1.1305			
Y	1.565	1.585	DT8695 A/B	1.572	1.572	1.568			
Z	0.178	0.198		0.188	0.188	0.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>DJP</i>
Date: 08/07/01

Audited by: <i>RF</i>
Date: 08/07/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

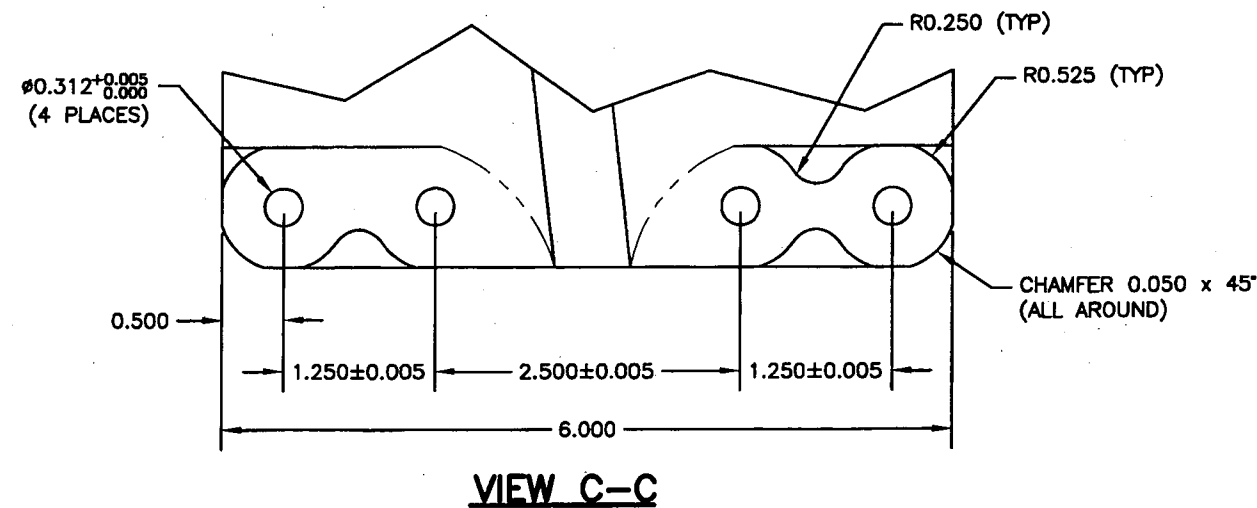
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

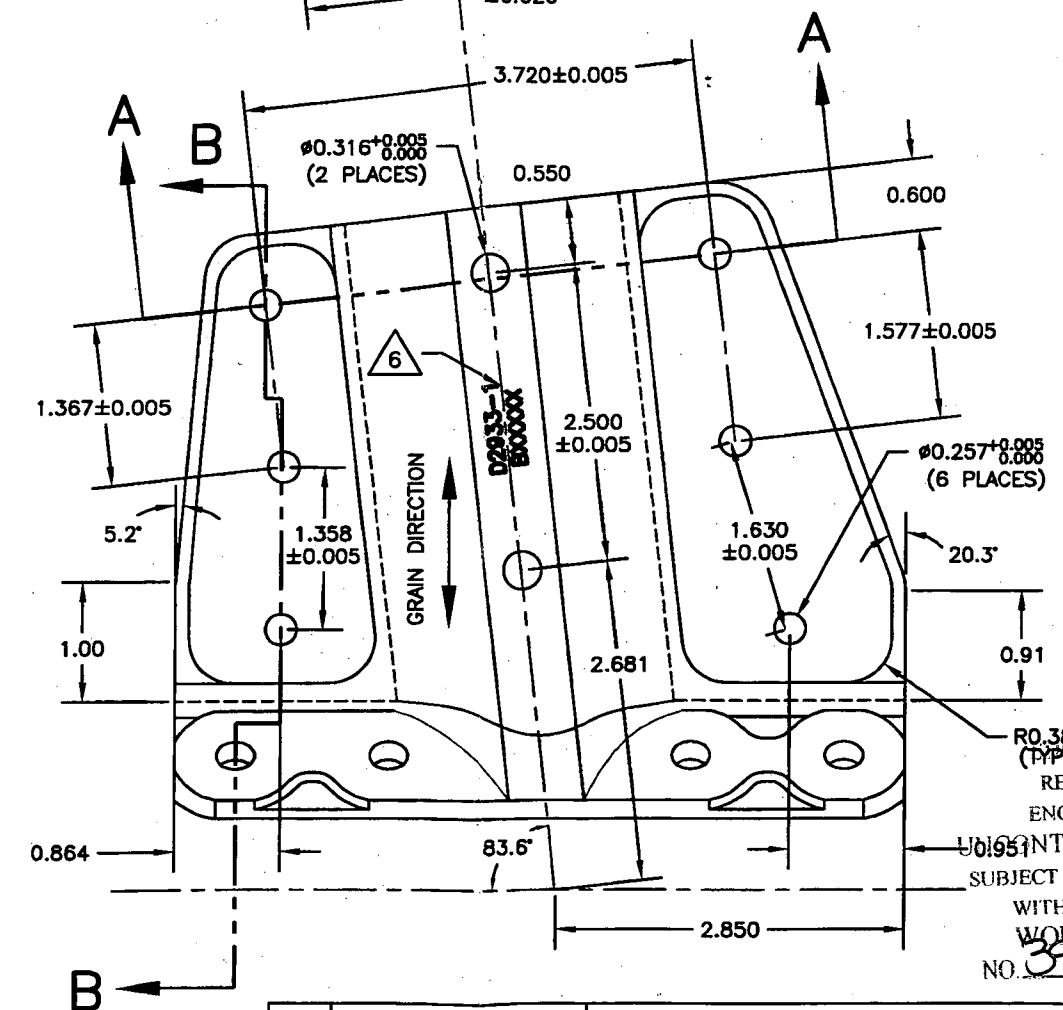
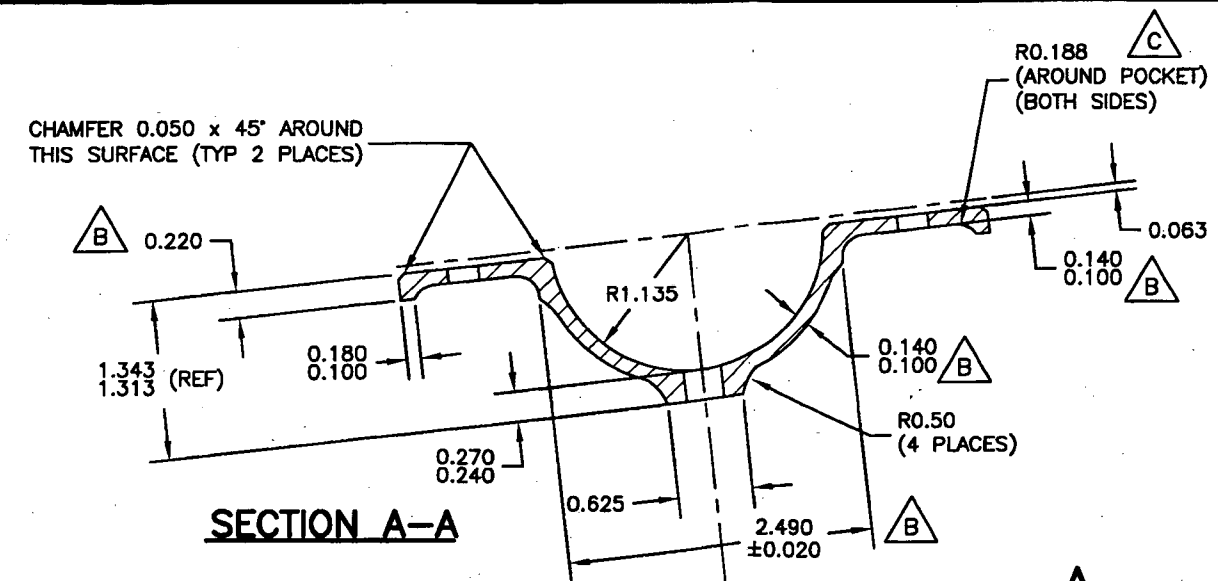
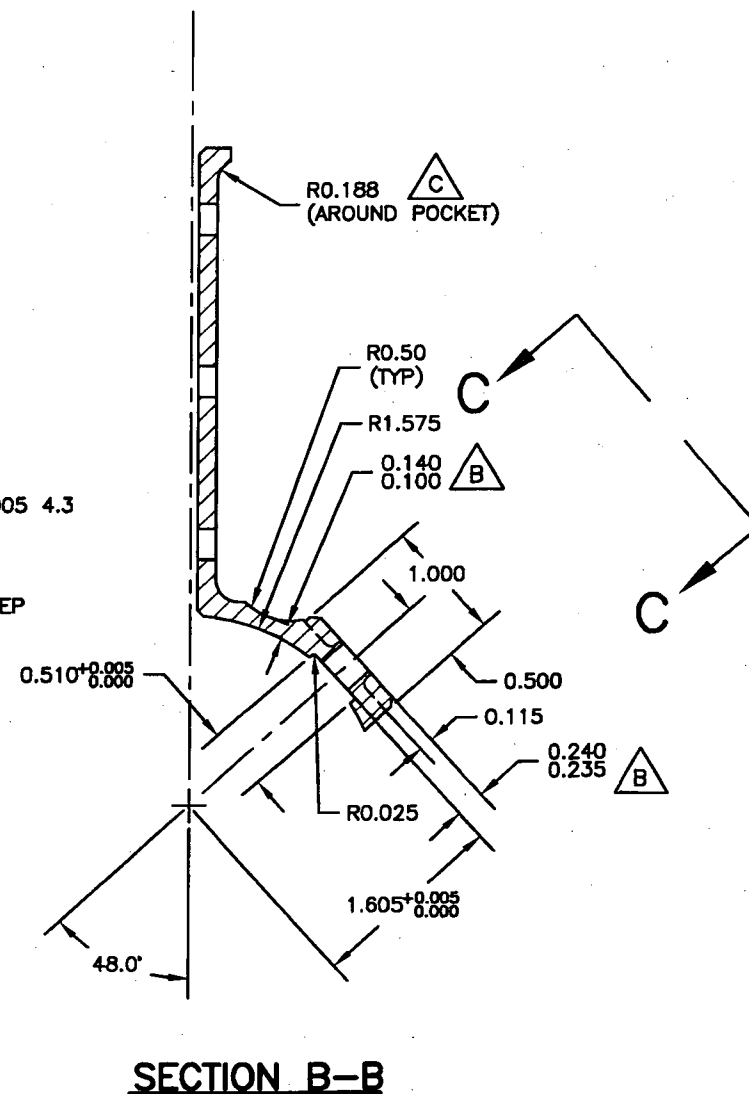




**D2933-1 LH SADDLE (SHOWN)**  
**D2933-2 RH SADDLE (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 39157

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE INSIDE
DRAWING NO. D2933		REV. C SHEET 1 OF 1
SCALE		2:3

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**DART** DART AEROSPACE USA, INC.  
 BELLEVUE, WA

RELEASED  
 07.02.12

